

Date: Thursday, 8/16/2007 9:13:34 AM  
 User: Jean-Luc Menard

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HOUSING WELDMENT  
 Job Number : 33982  
 Estimate Number : 11874  
 P.O. Number : Part Number : D2207041  
 This Issue : 8/16/2007 S.O. No. : Drawing Number : D2207 UNDER REVIEW  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 1/1 Type : LARGE FAB ASSY Drawing Revision : C  
 Previous Run : 32219 Material :  
 Due Date : 8/23/2007 Qty: 4 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By :  
 Comment : Est. C 01.10.18 Added Step 10 and 11 SM

OK PER  
 PREVIOUS ISSUE OF  
 REV. C 07.08.16

## Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description:

1.0 D2208 End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

End Cap

Pick:

Qty Part Number Description Batch  
 2 D2208 End cap

\* 335095 = 8  
~~B13261~~

*[Signature]* 08.03.17 4  
~~PD 07.08.17 (4)~~

2.0 D22071 Housing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Housing

Pick:

Qty Part Number Description Batch  
 1 D2207-1 Housing

\* 334326 = 4  
~~B33240~~

*[Signature]* 08.03.17 4  
~~PD 07.08.17 (4)~~

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D2207

Grind welds flush as per Dwg D2207

*[Signature]* 08.03.17 4  
 1- chamfer parts before  
 Welding

*[Signature]* 08.03.17 4  
~~PD 07.08.20 (4)~~

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*[Signature]* 08.03.18 (1)  
~~PD 07.08.20 (4)~~

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL FABRICATION RESOURCE 1

Drill holes using DT8557 as per Dwg D2207

*[Signature]* 08.03.18 4  
~~FF 07.08.21~~

334326

335095



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/03/18	#	<del>welding sign is wrong</del> of DWG in A 50063/18					

Part No: D2207-041 PAR #: N/A Fault Category: Prod / Prod. Large NCR: Yes No DQA: LD Date: 08/03/19  
 QA: N/C Closed: HA Date: 08/03/19

NCR: <u>33982</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/21	# 3.0	All four (4) D2207-041's were found with the end caps (D2206) welded on the outside of the housing's causing the weld to crack.	<i>[Signature]</i>	Scrap all four and Replace.	<i>[Signature]</i> 07-03-21	<i>[Signature]</i> 08/03/18	<i>[Signature]</i> 08/03/18	<i>[Signature]</i> 07/03/21
		R.C. old parts still in stock	<i>[Signature]</i>	Remove all old D2206 from stock & scrap.	<i>[Signature]</i> 07-03-18	<i>[Signature]</i> 08/03/18	<i>[Signature]</i> 08/03/18	<i>[Signature]</i> 08/03/18
07-03-17	3.0	weld all end cap on inside as per diag. 4 pos. grid flush	<i>[Signature]</i>	rework all parts	<i>[Signature]</i> 07-03-17	<i>[Signature]</i> 08/03/18	<i>[Signature]</i> 08/03/18	<i>[Signature]</i> 08/03/18
		R.C. welding symbol is wrong on DWG	<i>[Signature]</i>	change symbol on DWG	<i>[Signature]</i> 08-03-18	<i>[Signature]</i> 08/03/18	<i>[Signature]</i> 08/03/18	<i>[Signature]</i> 08/03/18

NOTE: Date &amp; initial all entries





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING WELDMENT

Job Number: 33982

Part Number: D2207041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*J 08/03/18 (4)*

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

*FL 08/03/18 (4)*

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M 107005*

*BL 08-03-18*

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-L 08/03/18 (4X)*

10.0 ALS71032130 Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Insert

Qty Part Number Description Batch  
4 ALS7-1032-130 Insert  
SEE QSI 017

*M 105730*

*m-l 08/03/18*

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Install AK57-1032-130 as per Dwg D2207

*M-L 08/03/18*

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*J 08/03/18 (4)*

13.0 PACKAGING 1 PACKAGING RESOURCE #1



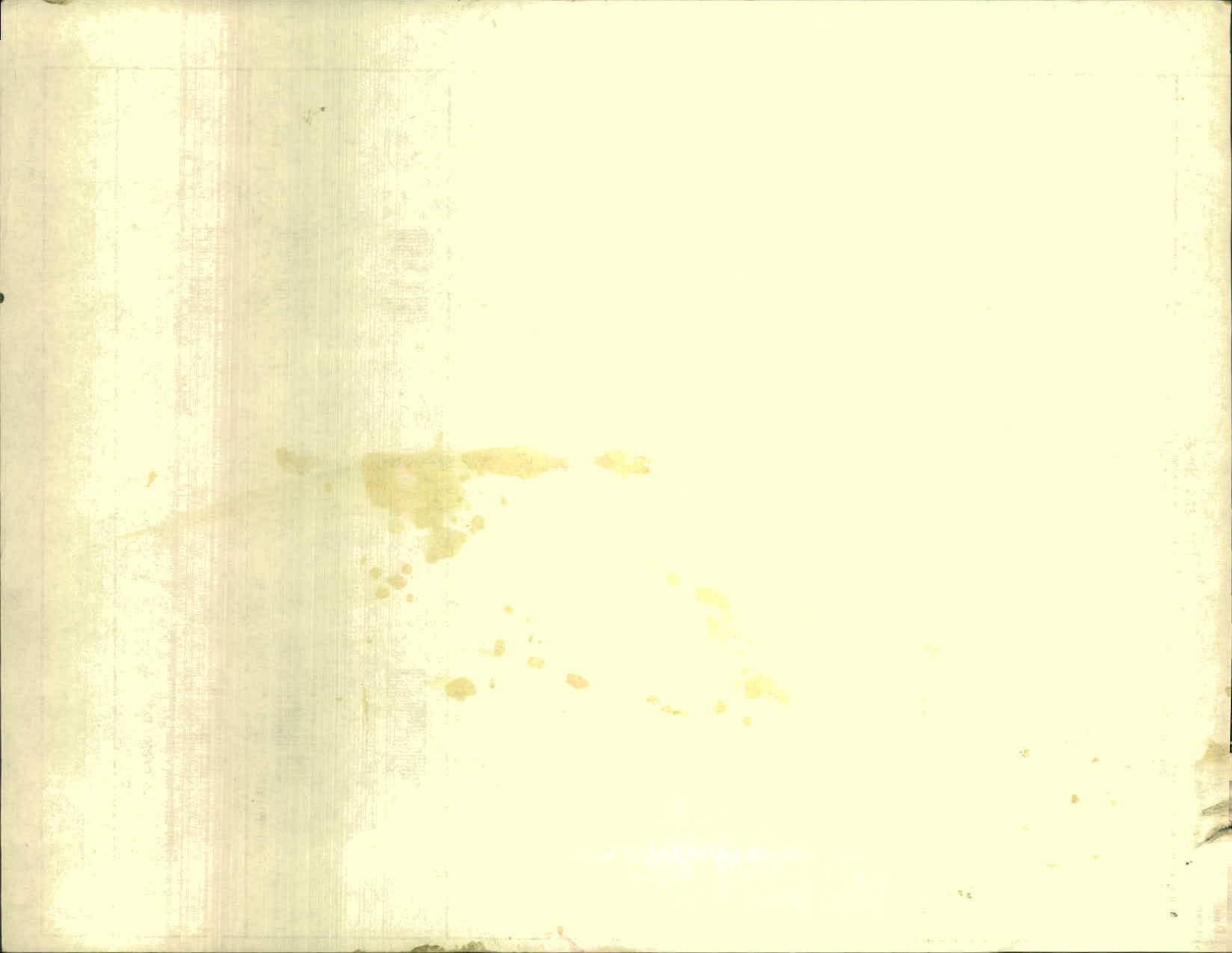
Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*777*

*8/3/18 56 (4X)*



Date: Thu 07/07/2017 9:13:34 AM  
User: Jean-Luc Merland

## Process Sheet

Customer: QUAD 001 Dart Helicopters Services

Drawing Name: HOUSING WELDMENT

Job Number: 33982

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



④

Comment: FINAL INSPECTION/W/O RELEASE

AD 08/03/17

Job Completion



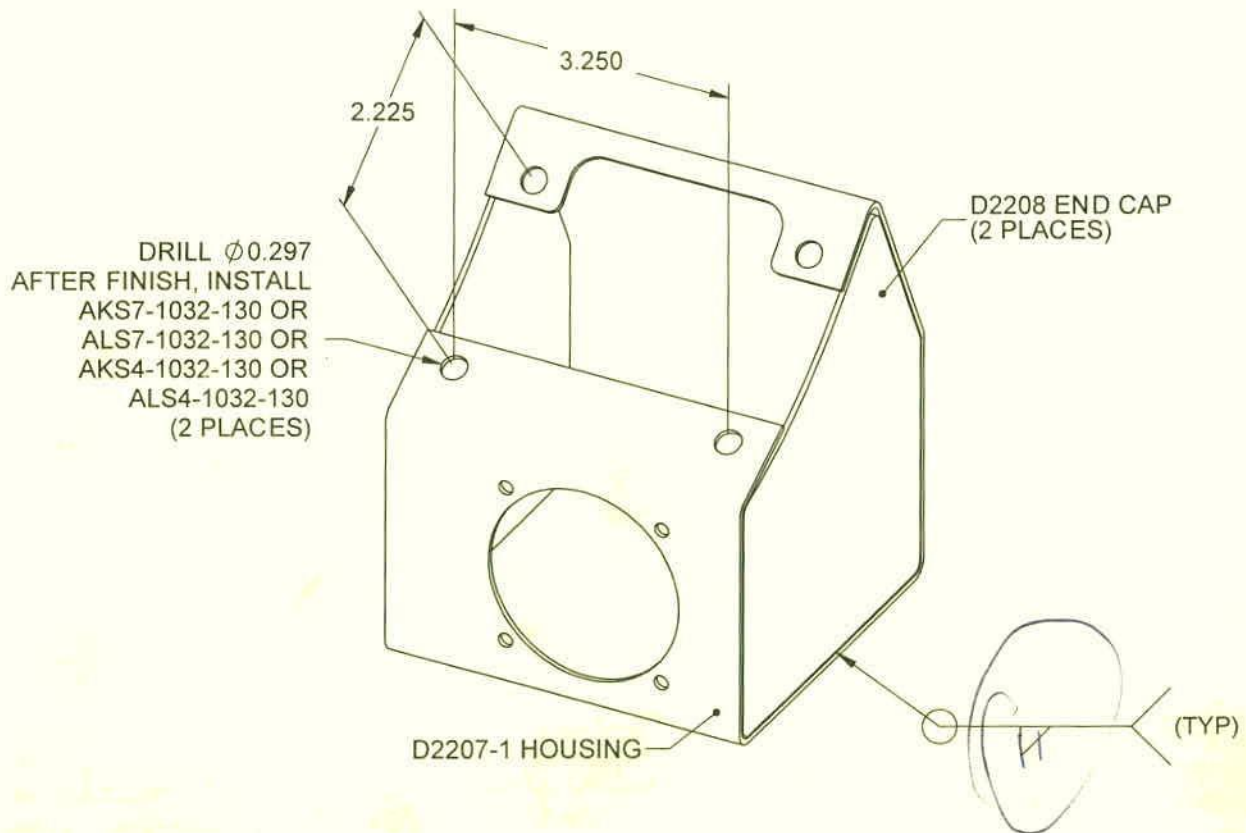
u 08-03-19







DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. <b>D2207</b>	REV. C SHEET 1 OF 2
DATE <b>07.06.28</b>		TITLE <b>HOUSING</b>	SCALE 1:2
REV	DATE	DESCRIPTION	
A	94.09.01	NEW ISSUE	
B	01.02.23	REDRAWN	
C	07.06.28	REDESIGN	



### D2207-041 FLAT PATTERN

**PRELIMINARY ISSUE**

#### NOTES:

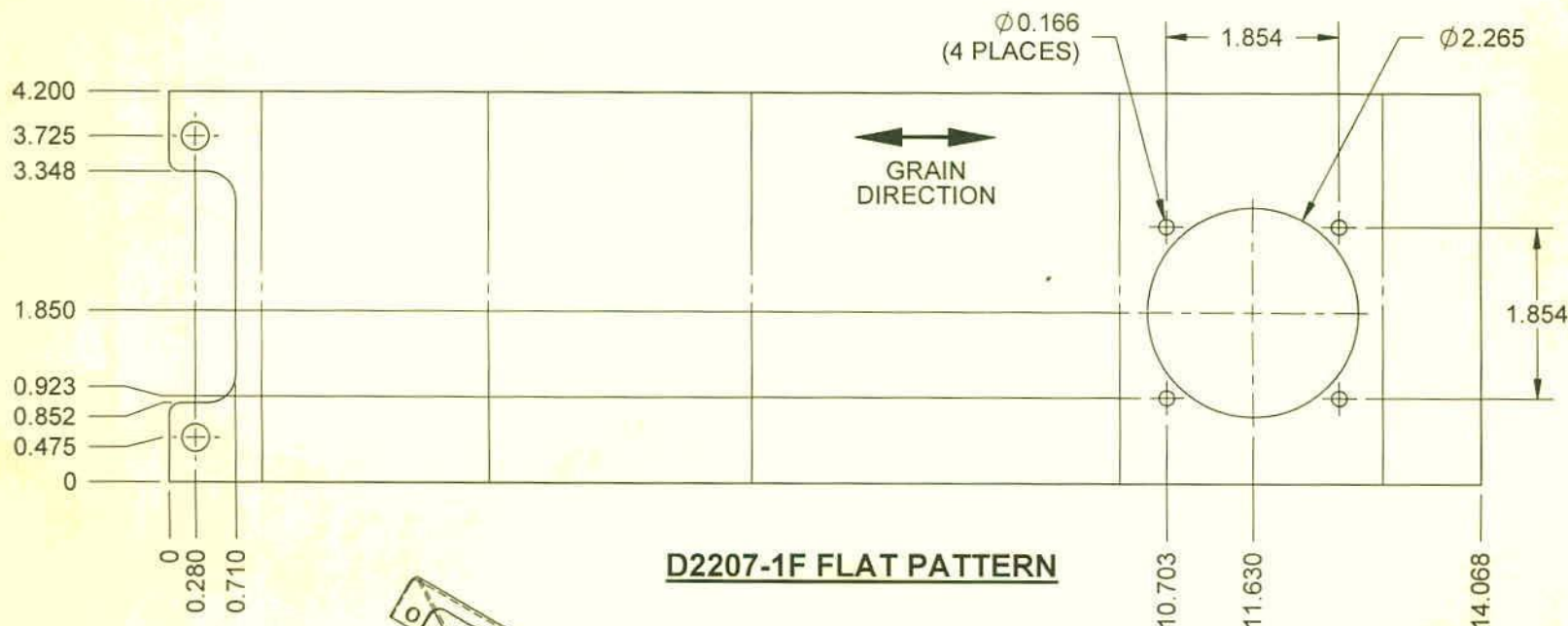
- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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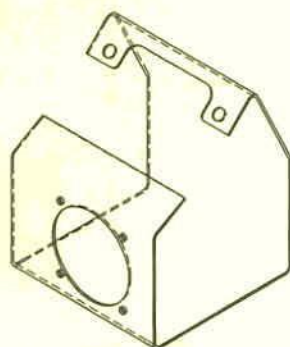
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**D2207-1F FLAT PATTERN**

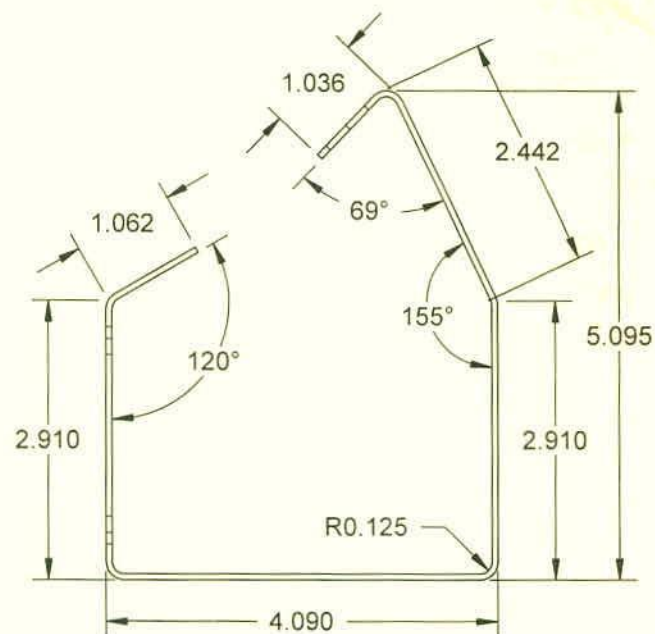


**ISOMETRIC VIEW**  
(SCALE 1 : 4)

**D2207-1 HOUSING**

**NOTES**

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.063) OR  
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



**D2207-1 BENDING DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE		DRAWING NO.	
07.06.28		D2207	SHEET 2 OF 2
		TITLE	SCALE
		HOUSING	1:2



PRELIMINARY ISSUE